

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003093**Date Inspected:** 24-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG side, bottom and deck panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA performed 10% Ultrasonic Testing (UT) verification on the following side and bottom panel weld joints: BP-004-xxx-003, 004, 005, 006 and 007 / SP-029-xxx-003, 004, 005, 006 and 007. All welds appeared to be compliant with AWS D1.5 2002 and the contract documents.

QA performed 10% Ultrasonic Testing (UT) verification on the following floor beam weld joints: FB-003-xxx-001, FB-003-xxx-006, FB-013-xxx-020 and FB-013-xxx-002. All welds appeared to be compliant with AWS D1.5 2002 and the contract documents.

QA observed ZPMC qualified welding personnel perform R1 SMAW UT weld repairs on joints connecting component identified as LD11C to floor beam @ PP-023 OBG segment 3BE.

QA observed ZPMC Ultrasonic Testing (UT) technicians Examine the following side panel weld joints: SEG-026A-001, 002, 003, 004, 005 and 006. QC accepted the following: 001, 002, 003 and 006. QC rejected the following: 004 and 005.

QA observed ZPMC Ultrasonic Testing (UT) technicians examine the following side or bottom panel weld joints: SEG-021A-005 and 006. ZPMC UT technicians appear to suspect weld cap indications in the second leg from the far side weld cap. ZPMC personnel will grind the weld cap in the suspect areas and re-UT at a later date.

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QA noted that ZPMC has excavated two areas on bottom panel weld joint SEG-023A-003 BP-030 to BP-084. Both areas measure approximately 80 to 100mm in length. The repair excavations appear to be due to UT non-compliance.

QA noted that ZPMC qualified welding personnel have completed 3G FCAW on one side of floor beam weld joints SSD12-PP028-014 and 133 on OBG segment 4BW.

Other general observations include ZPMC personnel fitting and welding OBG temporary support columns, grinding and weld bevel prep on various OBG components.



Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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